

Recommended stress-relieving treatments for wrought magnesium alloys

Alloy	Sheet								
	Annealed			Hard rolled			Extrusions and forgings		
	Temperature		Time, min	Temperature		Time, min	Temperature		Time, min
	°C	°F		°C	°F		°C	°F	
AZ31B	345	650	120	150	300	60	...	...	...
AZ31B-F	...	...	...	...	...	...	260	500	15
AZ61A	345	650	120	205	400	60	...	...	...
AZ61A-F	...	...	...	...	...	...	260	500	15
AZ80A-F	...	...	...	...	...	...	260	500	15
AZ80A-T5	...	...	...	...	...	...	205	400	60
HK31A	345	650	60	290	550	30	...	...	...
HM21A-T5	...	...	...	...	...	...	370	700	30
HM21A-T8	...	...	...	370	700	30	...	...	...
HM21A-T81	...	...	...	400	750	30	...	...	...
HM31A-T5	...	...	...	...	...	...	425	800	60
ZC71A-T5	...	...	...	...	...	...	330	625	60
ZK60A-F	230	450	180	...	...	...	260	500	15
ZK60A-T5	...	...	...	...	...	...	150	300	60

Note: Stress relieving after welding, to prevent stress-corrosion cracking, is necessary only for alloys that contain more than 1.5% aluminum. Source: *ASM Handbook, Vol. 4, Heat Treating*, ASM International, 1991, p 900